

**ABSTRACT**

A can end member has a center panel, a circumferential  
chuck wall, and a transition wall. The center panel is centered about  
a longitudinal axis and has a peripheral edge. The center panel also  
5 has a step portion located radially outwardly from the longitudinal  
axis. The step portion has an annular convex portion joined to an  
annular concave portion and displaces at least a portion of the center  
panel vertically in a direction parallel to the longitudinal axis. The  
curl defines an outer perimeter of the end member. The  
10 circumferential chuck wall extends downwardly from the curl to the  
transition wall. The transition wall connects the chuck wall with the  
peripheral edge of the center panel. The transition wall has a folded  
portion extending outwardly relative to the longitudinal axis.

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